

Monday, 9/11/2006 3:45:22 PM
User: Kim Johnston

Process Sheet

Split
SB 06/12/04

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING
Job Number : 28488-1
Estimate Number : 10336
P.O. Number : N/A
This Issue : 9/11/2006 S.D. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : 27562
Written By :
Checked & Approved By :
Comment : Est: D 05.06.21 Removed painting; Changed supplier
KJ/JLM

Part Number : D2807
Drawing Number : D2807 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 9/30/2006 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2009

C 206109112 (40)

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

2.0 SXF6S6050080S6L115N GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
SUPPORT PROP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

LB 06/10/10 (40)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J06 10:23 40

5.0 D28073 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

2 D2807-3 Lug Batch: B28489

B28489

45

B28647

35

SB 06/11/04

(40)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 28488

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

SR 06/12/04

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 206/12/04

(4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SR 06/12/04

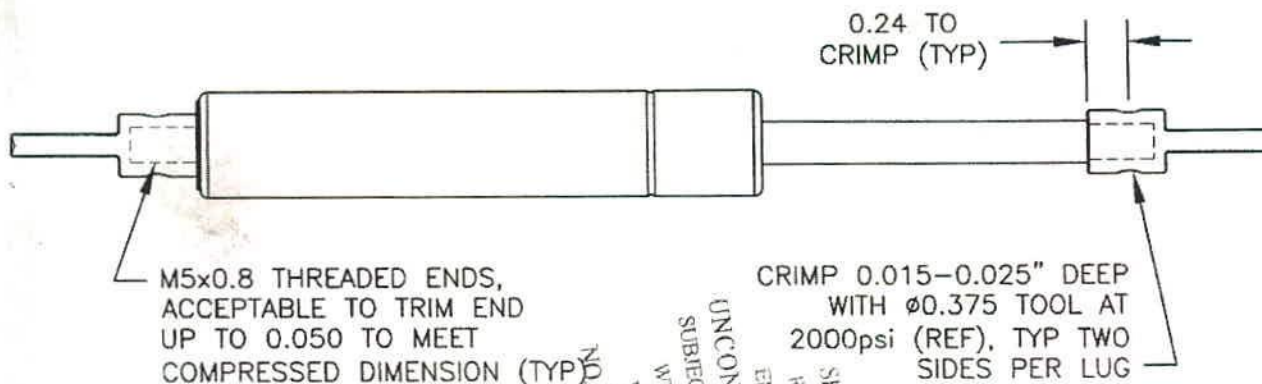
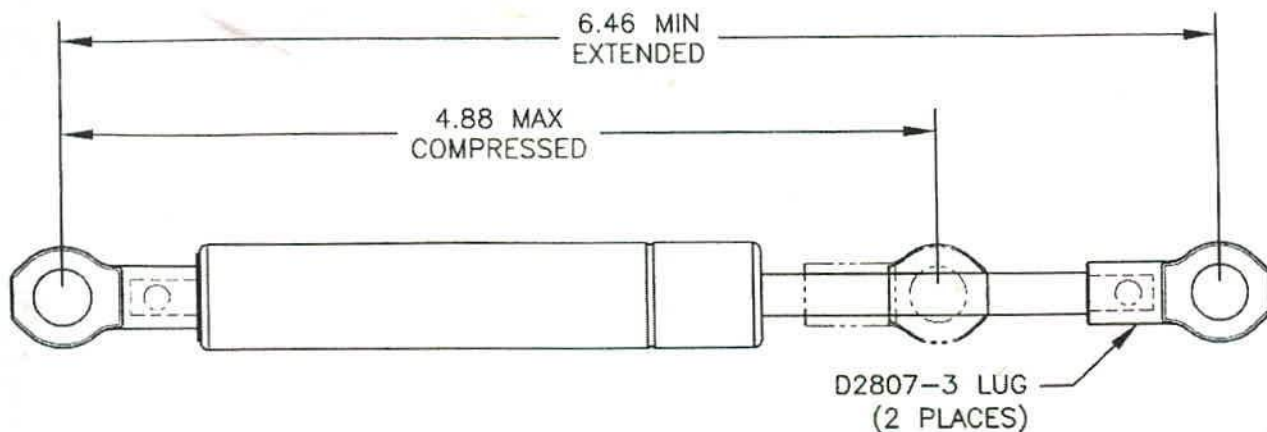
Job Completion



C 206/12/04

DART**RELEASED**
#05-06-16

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2807
DATE		TITLE
05.05.25		GAS SPRING
		SCALE
		1:1
		REV. C
		SHEET 1 OF 2
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG

**D2807 GAS SPRING**

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

58776/001

SERIAL No.	DUR REF.
	58776
DATE	
051006	
AC No.	AREA
2011	46
CUSTOMER REF. No.	
F100102009	

V.A.T. REGISTRATION No. GB/38 8577 7

INVOICE TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

DELIVERY TO:

DART AEROSPACE LTD
SHIP FEDEX ECONOMY SERV
ACC NO 151793240

V.A.T. REGISTRATION No. GB/38 8577 71

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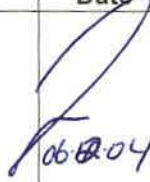
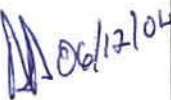


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FED EX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/04	60	1x 02807 is scrapped due to gauges on the shaft. Cause is unknown. 2x 02807-3 were installed, and crimped.		destroy & replace.	 06/12/04	 06/12/04	 06/12/04	 06/12/04

NOTE: Date & initial all entries